	er ID 97471 ruary 20, 2013 2:20:51 PM		*974	71*			AO	6		Page 1
Item ID: Revision ID: Item Name:	D3238-15 Plate		Accept	*N900	<u>040</u>	100)* s	etup Star Stop	ı VI .	S1* S2*
Start Date: Required Date: Reference:	2/20/2013 Start Qty: 16 2/22/2013 Req'd Qty: 16	1 ()		Cust Item Customer:						. 12
Approvals:	Process Plan: MF				ate:	- 	F	tun Star Stop		R1* R2*
Sequence ID/ Work Center II	Operation D Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp.
Draw Nbr	Revision Nbr		,							
D3238	Rev C									
*100	FLOW WATER JE	Т	0.00				16	٥		JM13-2-21
Waterjet FLOW CNC Waterj んないべるの (する)		as per Dwg D3238 Dwg Rev:_ if necessary	0.00 Prog Rev:	_ 2-			- ,			
110 *4.4.0*	QC2- Inspect parts	off machine FAI/FAIB	0.00				,			
110 QC Quality Control	Мето		0.00				. 16			JM-3-2-2
120	QC8- Inspect parts	- second check	0.00 7AS				1/			
120	Мето		0.00 13 2 2	1			16	· · · · · · · · · · · · · · · · · · ·		

Quality Control

WORK ORDER NON-CONFORMANCE / UPDATE Yes / No NCR: QA Closed: Date: AGAINST DEPARTMENT/PROCESS DISPOSITION Work Order: _____ Crosstube Water Jet Engineering Skid-tube Rework Prod. Eng. Coor. Part No. Machining Small Fab Quality Scrap Finishing Rec/Store/Packaging Other Thermoforming Use-as-is NCR No. Work Order Update Large Fab Composite Supplier Description of work order update Initial Action Sign & Root Verification QC Inspector Chief Eng Date Date Step Qty or Non-conformance Description Cause Doc/Data Equip/Tooling Operator Material Setup Other **Process** Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Pressure/Forced Bend Grain Ovalized Bending BOM/Route Temperature/Cure Hardware Over/Under tolerance Centre Not Concentric to O/S Broken/Damaged Weld Cracks Inspection Incomplete Part Incorrect Wrong Stock Pulled Crushed/Crimped Instructions Incomplete/Unclear Part Lost/Missing Burrs Cuffs Contamination Maintenance Part Moved Mislabeled Positioned Wrong Heat Treat Countersink Other Power Loss/Surge Inspection Strip in Tube **Cut Too Short** Misread

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Drill Holes

Drawing

Finish Folio DQA:

Date:

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 97471 *97471* Wednesday, February 20, 2013 2:20:51 PM Item ID: D3238-15 Accept *N900040100* Setup Start **Revision ID:** Stop Item Name: Plate **Start Date:** 2/20/2013 **Start Oty: 16.00** *16* **Cust Item ID:** Required Date: 2/22/2013 Req'd Oty: 16.00 *16* **Customer:** Reference: Run Process Plan: Date: Approvals: Tooling: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Tool # Plan Set Up/ Tool ID Accept Reject Reject Work Center ID Description Run Hours Otv Otv Code Number Stamp 130 Chemical Conversion Coat per OSI005 4.1 0.00 *120* HandFinish 0.00 Memo Hand Finishing 140 OC3- Inspect Part Finish

150

OC

150

Quality Control

Packaging

Packaging

Identify as per dwg & Stock Location 6 70

Memo

Memo

0.00

0.00 13.2 21

Page 2

Insp.

												DQA:	Da	te:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE		·	-	•	
												QA Closed:	Da	te:	wi
Work Ord	or.					DISPOSITION				AGAINST D	EF	PARTMENT	PROCESS		
i vvoik Olu	C1 .					Rework	٦		Skid-tube	Crosstube	٦		Water Jet		Engineering
Part I	No.					Scrap	1	i .	Machining	Small Fab	ᅦ	Pro	d. Eng. Coor.		Quality
						Use-as-is	1	Therm	noforming	Finishing		Rec/Stor	e/Packaging		Other
NCR I	No.					Work Order Update			Large Fab	Composite			Supplier		
Root					Descri	ption of work order update		nitial	Ac	tion	-	Sign &			
Cause		Date	Step	Qty		or Non-conformance	1	ief Eng		ription	ĺ	Date	Verificatio	n	QC Inspector
Doc/Data				Δ.,							┪				
Equip/Tooling								ì			١				
Operator			1												
Material													:		
Setup			<u> </u>												
Other														l	
Process															
Supplier															
Training															
Unapproved															
						F	AUL	T CATE	GORY						
Landi	ng (Gear				General		,		-		1		_	1
		Bending				Bend	<u> </u>	Grain		<u> </u>		Ovalized		L	Pressure/Forced
	<u> </u>	Centre No	ot Concer	ntric to	o/s	BOM/Route	_	Hardwa	re	<u> </u>		Over/Under	tolerance	L	Temperature/Cure
	L	Cracks				Broken/Damaged		1	ion Incomplete	L		Part Incorre		\vdash	Weld
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete/	Unclear		Part Lost/M	issing		Wrong Stock Pulled
		Cuffs				Contamination		Mainte	enance			Part Moved			
		Heat Trea	it			Countersink		Mislabe	eled			Positioned V	Vrong		7
		Inspectio	n Strip in	Tube		Cut Too Short	L	Misread	t			Power Loss/	Surge	L	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 97471 *97471* Wednesday, February 20, 2013 2:20:51 PM Item ID: D3238-15 Accept *N900040100* Setup Start **Revision ID:** Stop Item Name: Plate **Start Date: Start Qty:** 16.00 *16* 2/20/2013 **Cust Item ID:** Required Date: 2/22/2013 Rea'd Otv: 16.00 *16* **Customer:** Reference: Run Approvals: **Process Plan:** Date: Tooling: Date: Stop QC: Date: **SPC (Y/N):** Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Work Center ID Description Run Hours Code Oty Oty Number Stamp

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

160

160

Quality Control

Insp.

Page 3

NCR:	Yes /	No	WORK ORDER NON-CONFORM

DQA:	Date:	

NCR: Y	es / No				WORK ORDER NON-O	CONFO	ORN	MANCE / UPI	DATE	QA Closed:	Date	v:
Work Orde	r:				DISPOSITION	,				EPARTMENT,	_	
Part N	lo				Scrap Machining Small Fa			Crosstube Small Fab Finishing	Prod. Eng. Coor. Quality			
NCR N	lo				Work Order Update		Large Fab Compos				Supplier	
Root				Descri	ption of work order update	Initi	al	Act	ion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief	Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data				·			İ					
Equip/Tooling							-					
Operator		1					ĺ			İ		
Material		İ					ļ					
Setup												
Other							- 1					
Process												
Supplier										1		
Training												
Unapproved												
					F	AULT C	ATE	GORY				
Landir	ng Gear				General				-		- -	
	Bending				Bend	Gra	ain			Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to	o/s	BOM/Route	Hai	rdwa	re	L	Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Ins	pecti	on Incomplete	Ĺ	Part Incorre	ct	Weld
	Crushed/	Crimped.			Burrs	Ins	truct	ions Incomplete/l	Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Ma	ainte	nance		Part Moved		
	Heat Trea	at			Countersink	Mis	slabe	led		Positioned \	Wrong _	_
İ	Inspectio	n Strip in	Tube		Cut Too Short	Mi	sreac	ł		Power Loss,	'Surge	Other
Ì	Ripples in	n Bend			Drill Holes	Off	fset		_			
	Torque V	Vaves in 8	Extrusio	n	Drawing	Ou	it of C	Calibration				
Ì	Turning S				Finish	Ou	it of S	Sec _l uence				
	Wave/Tw				T _{Folio}	Ou	ıtside	Dimensions				

Picklist Print

Wednesday, February 20, 2013 2:20:51 P

Work Order ID:

97471

Parent Item:

D3238-15

Parent Item Name:

Plate

Start Date: 2/20/2013

Required Date: 2/22/2013

Page 1

Start Qty: 16.00

Required Qty: 16.00

Comments:

IPP Rev:A New Issue 06-10-20 EC

IPP Rev:B Now on Wateriet 07-01-26 JLM

	IFF Kev.b Now (on waterjet 07-01	-20 JLIVI				,						
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.020		Purchased	No		,	100	sf	0.0000	0.012	0.2021053	}		
5052-H32 .020 Sheet										0.25		Jw	113-2-21

119743

119743

											D	QA:	Da	ate: _	
NCR: Y	/es	/ No				WORK ORDER NON-C	100	NFORM	AANCE / UPDA	ATE		,		_	
		•									QA Clo	sed:	Da	ate:	
Marile Onde						DISPOSITION				AGAINST DE	PARTM	IENT,	PROCESS		
Work Orde	er: –					Rework	1 I		Skid-tube	Crosstube	7		Water Jet		Engineering
Part N	lo.					Scrap			Machining	Small Fab	1	Pro	d. Eng. Coor.	\vdash	Quality
Paili	v O	·				Use-as-is	1		noforming	Finishing	Rec		e/Packaging		Other
NCR N	do.					Work Order Update	1		~	Composite	1 '''	, 5001	Supplier	-	
(1011)	-				<u> </u>	Work order opaute]		24.86 . 4.		_			<u> </u>	
Root			· · · · · · · · · · · · · · · · · · ·		Descri	ption of work order update	T	nitial	Actio	n	Sign	&			
Cause		Date	Step	Qty	,	or Non-conformance	Ch	ief Eng	Descrip	otion	Dat	te	Verificatio	n	QC Inspector
Doc/Data															
Equip/Tooling					Ì										
Operator			i								i			ł	
Material															
Setup															
Other														•	
Process															
Supplier														ļ	
Training				:		•									
Unapproved				<u> </u>			<u> </u>				<u> </u>				
							AUI	T CATE	GORY						
Landi					_	General		1			7				
	—	Bending			ļ <u>.</u>	Bend	\perp	Grain			Ovalize				Pressure/Forced
	Щ	Centre No	t Concer	ntric to	O/S	BOM/Route	<u></u>	Hardwa			-4 '		tolerance		Temperature/Cure
		Cracks				Broken/Damaged	<u></u>	4	on Incomplete	<u> </u>	Part In			\vdash	Weld
	-	Crushed/0	Crimped.		L	Burrs	_	-	ions Incomplete/Un	nclear	Part Lo		issing		Wrong Stock Pulled
		Cuffs			- 1	Contamination		Mainte	nance		Part M	loved			

Mislabeled

Out of Calibration

Out of Secuence

Outside Dimensions

Misread

Offset

Countersink Cut Too Short

Drill Holes

Drawing

Finish Folio Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order: 974 7/
Description: Plate	Part Number: D3238-15
Inspection Dwg: D3238 Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
-----------------	-----------

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.75	+/-0.030	1.7494	-		٧	Themas
0.70	+/-0.030	Q 696"	-		>	
0.35	+/-0.030	0.347"			5	
0.36	+/-0.030	6.362"	_		ν	
1.030	+/-0.010	1.0312			٧	
Ø0.203	+0.005/-0.001	Q304.	_		ν	
4						
			:			
			· 			
		,				
			DA	8		

Measured by:	Jm	Audited by:	89	Prototype Approval:	N/A
Date:	13-2-21	Date:	13201	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.01.17	New issue	KJ/JLM LA	
В	07.02.23	Dwg Rev. updated	KJ/JLM	E

				DQA: ^{<}	Date:	
NCR:	Yes /	No	WORK ORDER NON-CONFORMANCE / UPDATE			

_											QA Closed:	Date):		
Work Orde	or.					DISPOSITION		AGAINST DEPARTMENT/PROCESS							
· · · · · · · · · · · · · · · · · · ·					Rework	1		Skid-tube	Crosstube		Water Jet	Engineering			
Part N	No.					Scrap	1	1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality		
	•					Use-as-is	1		noforming	Finishing	Rec/Stor	re/Packaging	Other		
NCR No.					Work Order Update]		Large Fab	Composite		Supplier				
Root					Descri	ption of work order update	11	nitial	Ad	ction	Sign &				
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector		
Doc/Data															
Equip/Tooling															
Operator						•	İ								
Material					,										
Setup															
Other															
Process															
Supplier															
Training															
Unapproved									<u> </u>			<u> </u>			
						·	AUL	T CATE	GORY						
Landi		3			_	General	$\overline{}$	l			1	Г	¬		
		Bending			_	Bend	\vdash	Grain		<u> </u>	Ovalized		Pressure/Forced		
	<u> </u>	Centre No	ot Concei	ntric to	o/s	BOM/Route	-	Hardwa		<u> </u>	Over/Under	-	Temperature/Cure		
		Cracks			ļ	Broken/Damaged	\vdash		ion Incomplete	<u></u>	Part Incorre	⊢	Weld		
	-	Crushed/	Crimped.		-	Burrs	_	l	tions Incomplete	/Unclear	Part Lost/M	issing [Wrong Stock Pulled		
	-	Cuffs			<u> </u>	Contamination		Mainte		<u> </u>	Part Moved	A for a value			
		Heat Trea		- 1	<u> </u>	Countersink	-	Mislab		<u> </u>	Positioned \		Joshan		
	-	Inspectio		Tube	-	Cut Too Short	\vdash	Misrea	a		Power Loss,	'Surge [Other		
	<u> </u>	Ripples in			<u> </u>	Drill Holes	_	Offset	Calibratian						
	\vdash	Torque W			n	Drawing	-		Calibration						
	Turning Sequence				1	Finish		Out of Sequence							

Outside Dimensions

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



	DESIG	N 4	DRAWN BY		SPACE LTD INTARIO, CANADA
Ī	CHECK	KED	APPROVED	DRAWING NO.	REV. C
				D3238	SHEET 1 OF 3
ſ	DATE		····	TITLE	SCALE
╽	07.0	02.19		PLATE	1:1
	Α		03.11.25	NEW ISSUE	-
	В		07.01.17	ADD -21/-23/-25/ CHANGE -11/-13/-	/-31/-33/-35; -15 TO 6061-T6

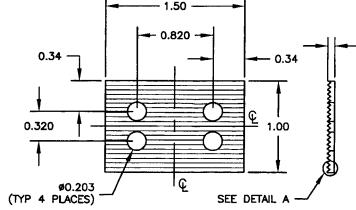
ADD 5052-H32 OPTION

RELEASED

C

07.02.20

07.02.19



D3238-3 PLATE (SHOWN)

(TYP 2 PLACES)

D3238-13 PLATE (SAME, EXCEPT 0.020 THICK AND NO SERRATIONS)

NOTES:

1) MATERIAL -1/-3/-5/-21/-23/-25 PLATE:

ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S)

0.075

-11/-13/-15/-31/-33/-35 PLATE:

ALUMINUM 6061-T6/-T62 SHEET, 0.020 THICK, PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.020) OR

ALUMINUM 5052-H32 SHEET, 0.020 THICK, PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32S.020)

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) SEE SHEET 3 FOR DETAIL A
- 7) PARTS ARE SYMMETRIC ABOUT &

DAY MAN

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						,						DQA:	Date	e: _			
NCR:	Yes	/ No				WORK ORDER NON-	100	NFORM	MANCE / UP	DATE							
												QA Closed:	Date	e:			
Mark Ord						DISPOSITION		AGAINST DEPARTMENT/PROCESS									
Work Ord	er.			·		Rework	٦		Skid-tube	Crosstube	_	I	Water Jet	\neg	Engineering		
Part I	Nο					Scrap	-	•	Machining	Small Fab	\dashv	Pro	d. Eng. Coor.	ᅱ	Quality		
1 411	10.	***************************************				Use-as-is	-		noforming	Finishing	\dashv	1	e/Packaging	ᅱ	Other		
NCR I	No.					Work Order Update	1	t	Large Fab	Composite	\dashv	,	Supplier	\dashv			
				·		· -			• Ш	, ,							
Root					Descri	ption of work order update		nitial	Ac	tion		Sign &		\Box			
Cause		Date	Step	Qty	(or Non-conformance	Cr	ief Eng	Desc	ription		Date	Verification		QC Inspector		
Doc/Data								,									
Equip/Tooling								·									
Operator																	
Material																	
Setup														1			
Other	L																
Process	匚				:												
Supplier	L																
Training	Ш													İ			
Unapproved																	
							AUI	T CATE	GORY								
Landi	_	1				General	_	1		1	_	7	г		1 .		
Bending						Bend	ļ	Grain			<u> </u>	Ovalized			Pressure/Forced		
	<u></u>	Centre No	ot Concer	ntric to	o/s	BOM/Route	—	Hardwa				Over/Under tolerance			Temperature/Cure		
		Cracks				Broken/Damaged	 	1	on Incomplete		_	Part Incorrect			Weld		
1	Crushed/Crimped				Burrs		Instructions Incomplete/Unclear				Part Lost/Missing		i	Wrong Stock Pulled			

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Part Moved Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

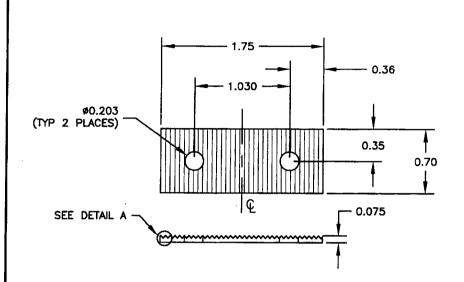
Inspection Strip in Tube

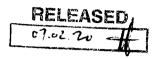
Torque Waves in Extrusion

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

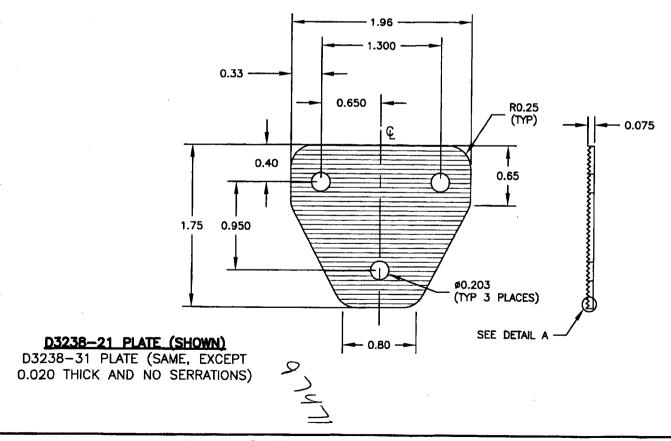


DESIGN #	DRAWN BY		EROSPACE LTD BURY, ONTARIO, CANADA
CHECKED	APPROVED //	DRAWING NO.	REV. C
LLE	-#	D3238	SHEET 2 OF 3
DATE		TITLE	SCALE
07.02.19		PLATE	1:1





D3238-5 PLATE (SHOWN) D3238-15 PLATE (SAME, EXCEPT 0.020 THICK AND NO SERRATIONS) 606176 0.020"



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									DQA:	Date:	
NCR: Y	res / N	0			WORK ORDER NON-CONFORMANCE / UPDATE					Date:	
Work Orde	ar.				DISPOSITION			AGAINST DEI	PARTMENT/	PROCESS	
Part N	lo				Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite				Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initial	nitial Action		Sign &		
Cause	Date	Step	Qty	,	or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator		į]		•		·	
Material											
Setup									`		
Other											
Process			1					-			
Supplier											
Training											

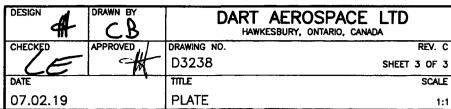
FAULT CATEGORY

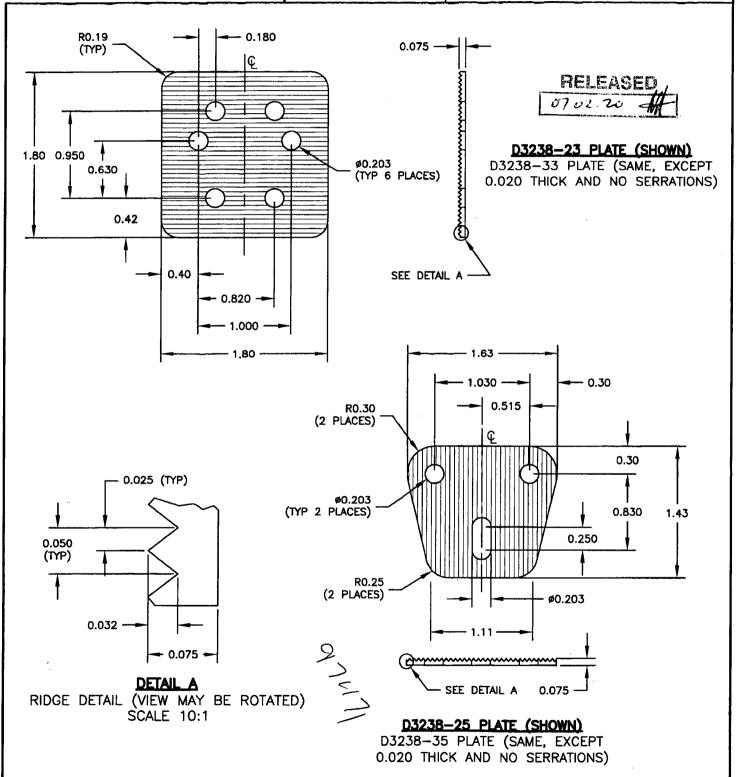
Landing Gear				General		_		_		_	
		Bending		Bend		Grain		Ovalized		Pressure/Forced	
		Centre Not Concentric to O/S		BOM/Route		Hardware		Over/Under tolerance		Temperature/Cure	
	-	Cracks		Broken/Damaged		Inspection Incomplete		Part Incorrect	L	Weld	
[Crushed/Crimped.	rimped. Burrs			Instructions Incomplete/Unclear	Part Lost/Missing			Wrong Stock Pulled	
[Cuffs		Contamination		Maintenance Part Moved					
[Heat Treat		Countersink		Mislabeled		Positioned Wrong			
[Inspection Strip in Tube		Cut Too Short		Misread		Power Loss/Surge		Other	
		Ripples in Bend		Drill Holes		Offset	Offset				
		Torque Waves in Extrusion		Drawing		Out of Calibration					
		Turning Sequence		Finish		Out of Sequence	Out of Sequence				
	Wave/Twist in Tube Folio					Outside Dimensions					

Unapproved

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										DQA:	Date:					
NCR: Ye	es / No				WORK ORDER NON-0	CONF	ORN	IANCE / UPDATI		QA Closed:	Date:					
· · · · · · · · · · · · · · · · · · ·					DISPOSITION	T	AGAINST DEPARTMENT/PROCESS									
Work Order	r:				DISPOSITION			A	IGAINST DEP	AKTIVICINI	PROCESS					
Part No	0.				Rework Scrap Use-as-is] 	Skid-tube Crosstube Small Fab Thermoforming Finishing				Water Jet d. Eng. Coor. e/Packaging	Engineering Quality Other				
NCR No	0				Work Order Update]	l	Large Fab Cor	mposite		Supplier					
Root				Descri	ption of work order update		ial	Action		Sign &	· · · · · · · · · · · · · · · · · · ·					
Cause	Date	Step	Qty	(or Non-conformance	Chief	Eng	Description	n	Date	Verification	QC Inspector				
Doc/Data]							
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-	Cracks	C-:		<u> </u>	Broken/Damaged	\vdash	-	on Incomplete		Part Incorrect Part Lost/Mi	-	Wrong Stock Pulled				
H	Crushed/ Cuffs	crimpea.		-	Burrs Contamination			ons Incomplete/Unclea		Part Moved	223118					
-	Heat Trea			-	Countersink	\vdash	islabel		 	Positioned V	Vrong					
-	Inspection	-	Tubo	 	Cut Too Short	\vdash	israbei			Power Loss/		Other				
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